



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6205G21631-3G

Job Sheet 166447



Part No: RBW6205G21631-3G

Job Qty: 1 ea

Part Name: Tool, M/R Damper Attaching Bolt Removal



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/5/17

Job Tracking No:

Due Date: 10/30/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/30/17	0.00	0.00	Start up container	MLC
110	Small Fab	1 pcs	10/30/17	0.00	0.00	Small Fab	MDR
120	QC	1 pcs	10/30/17	0.00	0.00	QC4 QC5	38 2018
130	Packaging	1 pcs	10/30/17	0.00	0.00	Packaging3	54 JAN 2 2018
140	QC21-SA	1 Ea	10/30/17	0.00	0.00	QC21	21 9-09

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver as per Dart QSI 044 2-Transfer drill Dart placard RB41011
Descriptions: into Pelican case APP-1650-E as per Dart DSK 3-Deburr holes and remove chips from case. 4-Rivet Dart
placard to Pelican case as per DSK 5-Glue placard RBW6205G21631-3G-1 to RBW6205G21631-3G-5 foam
as per DWG. 6-Pack case as per DWG.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	APP-1650-E	1	0	0	0
	RB41011	1	0	0	0
	RBW6205G21631-3G-1	1	0	0	0
	RBW6205G25031-3G	1	0	0	0
	RBW6205G25331-3G	1	0	0	0
	RBW6205G25651-3G	1	0	0	0
	RBW6205G25751-3G	1	0	0	0
	RBW6205G25831-3G	1	0	0	0
	RBW6205G26151-3G	1	0	0	0
	RBW6205G26251-3G	1	0	0	0
	RBW6205G26351-3G	1	0	0	0
	SCR-55H	1	0	0	0
	007				

Part Specifications

Specifications could not be found.

Plex 10/5/17 3:15 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Step #: _____	DISPOSITION Rework ☐	AGAINST DEPARTMENT / _____ Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%;">Engineering</td> <td style="width:50%;">☐</td> </tr> <tr> <td>Quality</td> <td>☐</td> </tr> <tr> <td>Other</td> <td>☐</td> </tr> </table>	Engineering	☐	Quality	☐	Other	☐																																												
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Description Work Order De		VRB (QSI042) Approval																																																			
 S035363 Tool, M/R Damper Attaching Bolt Removal		Completed By																																																			
PART NO: Original Serial #: S035363 Revision: Operation: Change No:		RBW6205G21631 - 3G Start up Operation 01/25/18 Job No: 166447																																																			
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Work Order ID 166447

Friday, September 22, 2017 11:47:18 AM

166447

Page 1

Item ID: RBW6205G21631-3G

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tool, M/R Damper Attaching Bolt Removal

Start Date: 9/25/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/30/2017 Req'd Qty: 1.00

1

Customer:

Reference:

DAS

21

9-30

Approvals:

Process Plan:

Date:

SEP 22 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

RBW6205G21631-3G 1

110

0.00

110

Small Fab

Memo

0.00

Small Fab

1-Engrave placard RB41011 using marktronic engraver as per Dart QSI 044

2-Transfer drill Dart placard RB41011 into Pelican case APP-1650-E
as per Dart DSK

3-Deburr holes and remove chips from case.

4-Rivet Dart placard to Pelican case as per DSK

5-Glue placard RBW6205G21631-3G-1 to
RBW6205G21631-3G-5 foam as per DWG.

6-Pack case as per DWG.

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : _____							

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐				

Friday, September 22, 2017 11:47:21 AM

Parent Item: RBW6205G21631-3G

RRW6205G21631-3G

Parent Item Name: Tool, M/R Damper Attaching Bolt Removal

Start Date: 9/25/2017**Required Date:** 10/30/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev.A 17.09.01 New issue DP Verify DD

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Friday, September 22, 2017 11:47:21 AM

Page 2

Work Order ID: 166447

166447

Parent Item: RBW6205G21631-3G

RBW6205G21631-3G

Parent Item Name: Tool, M/R Damper Attaching Bolt Removal

Start Date: 9/25/2017

Required Date: 10/30/2017

Start Qty: 1.00

Required Qty: 1.00

RBW6205G26151-3G Manufactured No

110 Each 0.0000 1 1

RBW6205G26151-3G

Protection Bushing, Lever

RBW6205G26251-3G Manufactured No

110 Each 0.0000 1 1

RBW6205G26251-3G

Spacer

RBW6205G26351-3G Manufactured No

110 Each 0.0000 1 1

RBW6205G26351-3G

Lever Protection

SCR-55H Purchased No

110 Each 0.0000 1 1

SCR-55H

Pump Cylinder Set

RBW6205G21631-3G-3

qty 1

Batch: _____

RBW6205G21631-3G-5

qty 1

Batch: _____

Friday, September 22, 2017 11:47:21 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

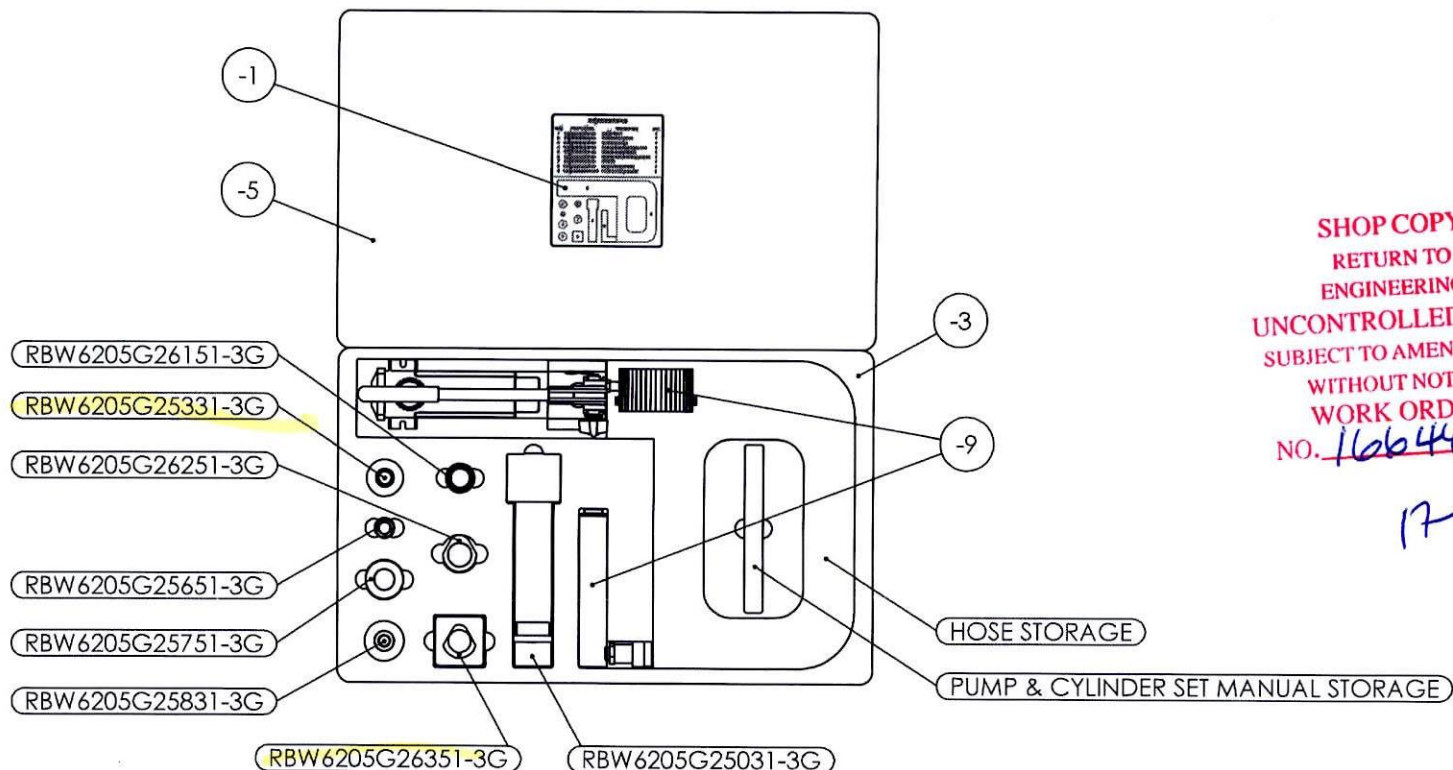
QA Closed: _____ Date: _____

Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	6/2/2017	DPD	JAG



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WORK ORDER
NO. 16644745
1709-22

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	CLAMP ASSY		RBW6205G25031-3G	1
				1	PULLER ASSY, HUB		RBW6205G25331-3G	1
				1	GUIDE BUSHING		RBW6205G25651-3G	1
				1	PROTECTION BUSHING, HUB		RBW6205G25751-3G	1
				1	PULLER ASSY, LEVER		RBW6205G25831-3G	1
				1	PROTECTION BUSHING, LEVER		RBW6205G26151-3G	1
				1	SPACER		RBW6205G26251-3G	1
				1	LEVER PROTECTION		RBW6205G26351-3G	1
			-1	1	CONTENTS PLACARD	PLASTIC		2
		B/O	-3	1	BOTTOM FOAM	ETHAFOAM 220, BLACK	8.67 X 17.97 X 29.01 (CASE SOLUTIONS)	3
		B/O	-5	1	TOP FOAM	ETHAFOAM 220, BLACK	1.77 X 18.10 X 29.19 (CASE SOLUTIONS)	4
		B/O	-7	1	CASE	PLASTIC	PELICAN #APP-1650-E	1
		B/O	-9	1	PUMP CYLINDER SET		5 TON (ENERPAC #SCR-55H)	N/S
		B/O		1	DART PLACARD	ALUMINUM	RB41011	N/S

NOTE:
REF. AGUSTA T/N: 3G6205G21631.

DART AEROSPACE			
TITLE			
TOOL M/R DAMPER ATTACHING BOLT REMOVAL			
DWG NO.			REV
RBW6205G21631-3G			1
MATL		UNLESS OTHERWISE SPECIFIED	
TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
DRAWN BY:		.X ± .1 SURFACES = 125/	
CHECKED:		1. BREAK ALL SHARP EDGES	
OPPS APPR:		.015 x 45° OR .015R	
QA APPR:		2. DIMENSIONAL LIMITS APPLY	
APPROVED:		AFTER PLATING	
SCALE		3. INTERPRET DIM AND TOL PER	
1:10		ASME Y14.5M-2009	
DATE		USED ON MODEL	
5/18/2017		AW139	
SHEET 1 OF 4			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							